

Work Order ID 55810

Tuesday, February 02, 2010 12:46:36 PM



Page 1

Item ID: D3443-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Weldment Assembly

Start Date: 2/3/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 2/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *10-02-02*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3443	Rev C

100	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3443								

buffing QAR 10-02-16

(Lx) 10/02/09

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

PD 10.02.09 (6)

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

=> 10/02/10

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

11/13/10

Memo

1-Mask holes as per dwg D3443

START TIME: 7:00AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 7:30AM

0.00

⇒ M 10/02/17

(X6) 7

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BL 10-02-17

(6) 4

150



Small Fab

Small Fab

Small Fab

0.00

Memo

Assemble bearing and ball plungers as per dwg D3443 using DT9518

0.00

Ensure bearing rotates smoothly

EP 10/02/18

(6)

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Accept



Setup Start



Revision ID:

Stop



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Start Date: 2/3/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 2/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/02/18

Memo

0.00

(46)

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

P 10/2/18 (6)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/18

MF 10-2-18

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, February 02, 2010 12:46:35 PM

Page 1

Work Order ID: 55810

Parent Item: D3443-041

Parent Item Name: Strut Weldment Assembly

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Start Date: 2/3/2010

Required Date: 2/15/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3443-1 Manufactured No



Lug

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

46143

1

51308

3

Main Warehouse

WA

7

53698

7

D3443-5 Manufactured No



Tubing

D3453-1 Manufactured No



Clevis

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

10

53732

10

Main Warehouse

st92

10

52986

10

6.0000
Cpl 10/02/09

stk

1 (3) Cpl

1 (3) Cpl

355808 (6) Cpl 10/02/09

Cpl 10/02/09

stk

1 (6) Cpl

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 2

Tuesday, February 02, 2010 12:46:35 PM

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Parent Item: D3443-041



Parent Item Name: Strut Weldment Assembly

Start Date: 2/3/2010

Required Date: 2/15/2010

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3965-4 Manufactured No



Bearing, Spherical

100 Each 8.0000 6.0000



EP 10/02/18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8

53680

8

6

D3966-4-750 Manufactured No



Pin, Dowel

100 Each 49.0000 12.0000



EP 10/02/09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

49

53631

49

1 (12) CPL

Tuesday, February 02, 2010 12:46:35 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

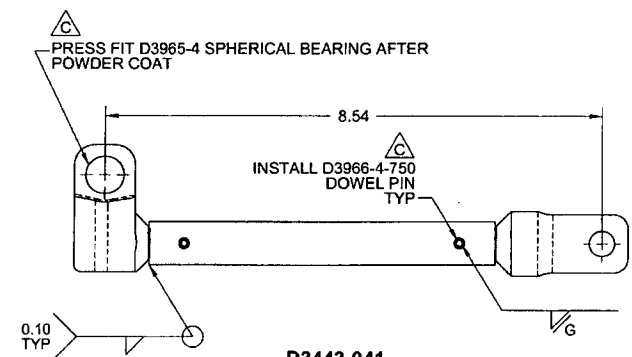
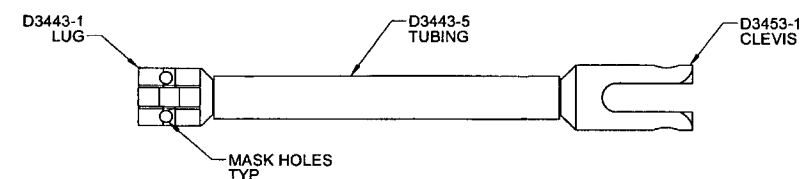
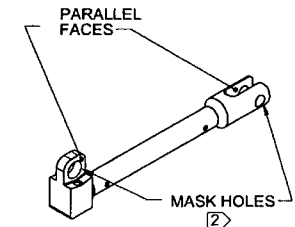
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3443-041

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY 041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

#55810

RELEASED
09/08/05

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAU P/N (ZN C6-1, B5-2); D3966-4-750 WAS McMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø 0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3443** REV. C
TITLE **STRUT WELDMENT ASSEMBLY** SCALE **NTS**

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

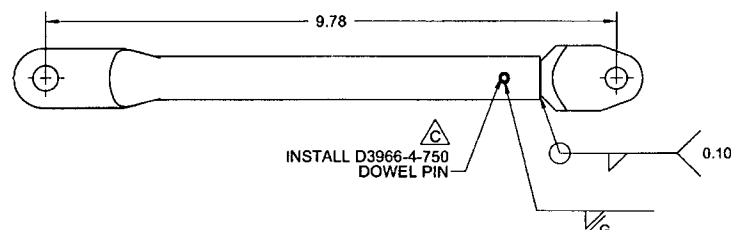
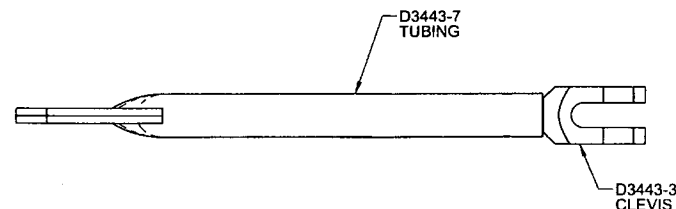
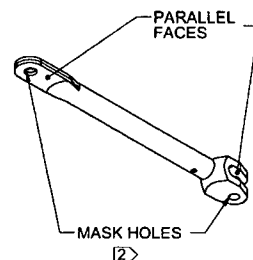
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NOTE: Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY NTS	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
01/08/25/14

#55810

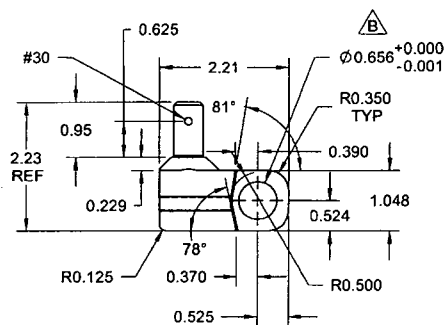
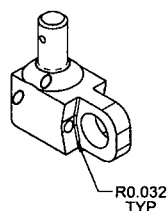
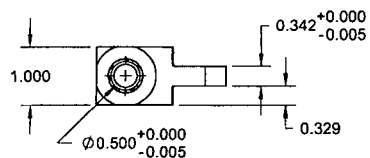
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

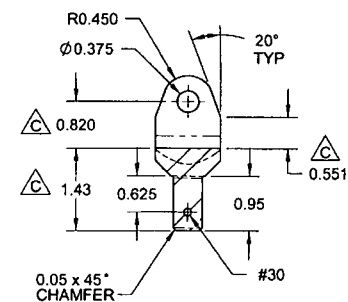
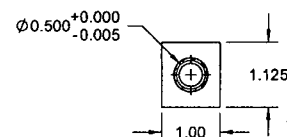
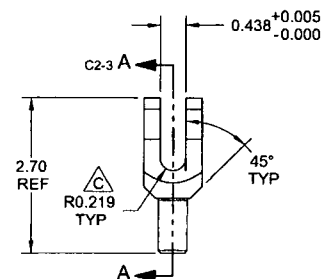
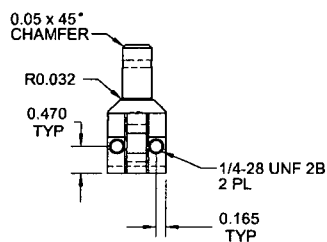
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D3443-1 LUG



SECTION A-A C4-3



D3443-3 CLEVIS

#55810

RELEASED
09/06/25/14

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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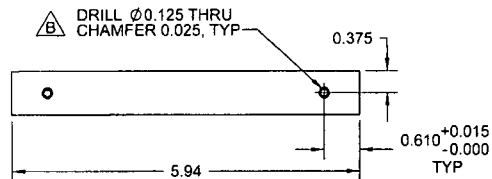
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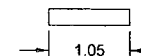
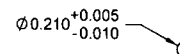
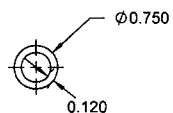
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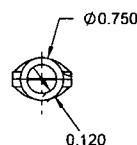
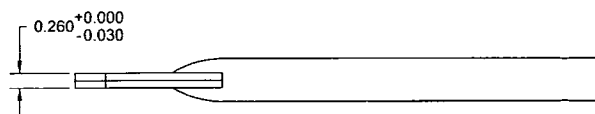
NOTE: Date & initial all entries



D3443-5 TUBING

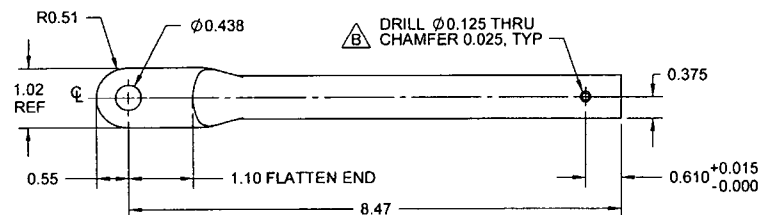


D3443-9 PIN



D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A






D3443-7 TUBING

D3443-5/7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

55010

RELEASED
07/08/25 M

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	RF		DRAWING NO.	REV. C
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APPROVED			TITLE	SCALE
DE APPR.			STRUT WELDMENT ASSEMBLY NTS	
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